

Date: Wednesday, 25/06/2008 9:25:42 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE GUIDE
Job Number : 40047	
Estimate Number : 10484	
P.O. Number :	Part Number : D34401
This Issue : 25/06/2008 S.O. No. :	Drawing Number : D3440 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 39963	Material :
Written By :	Due Date : 10/07/2008 Qty: <sup>10</sup> Um: Each
Checked & Approved By : <u>JL 08.6.25</u>	
Comment : Est. A 05.08.10 New issue KJ/JLM	
Est B 08.06.24 Re-formated EC verified by:DD	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2000X04000	6061T6 Bar 2.0" x 4.0"
-----	--------------------	------------------------



*40315* Comment: Qty.: 0.3885 f(s)/Unit Total : 1.9425 f(s)

6061T6 Bar 2.0" x 4.0"

Batch: U18169JL 08/07/04

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks as per folio

JL 08/07/03

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine as per Folio FA 551 and Dwg D3440

DJP 08/07/06

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP 08/07/06

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

84 08/07/04

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS / Fd.(X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/06/2008 9:25:42 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE GUIDE

Job Number: 40047

Part Number: D34401

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



m107925



(P12) →

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:30

OVEN TEMPERATURE:

320

FINISH TIME:

10:00

BL / R12 08/07/09

(107)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S08/07/09

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Pat - E.

CMF 08-07-14

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/15

Job Completion



mf 08-07-14

# Dart Aerospace Ltd

W/O: 40047		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08-07-09	7.0	remove white Powder coat for Green sandtex Add A masking detail/note to mask as per drawing detail "3". permanent change	E	08.07.09		08/07/09	08/07/09	

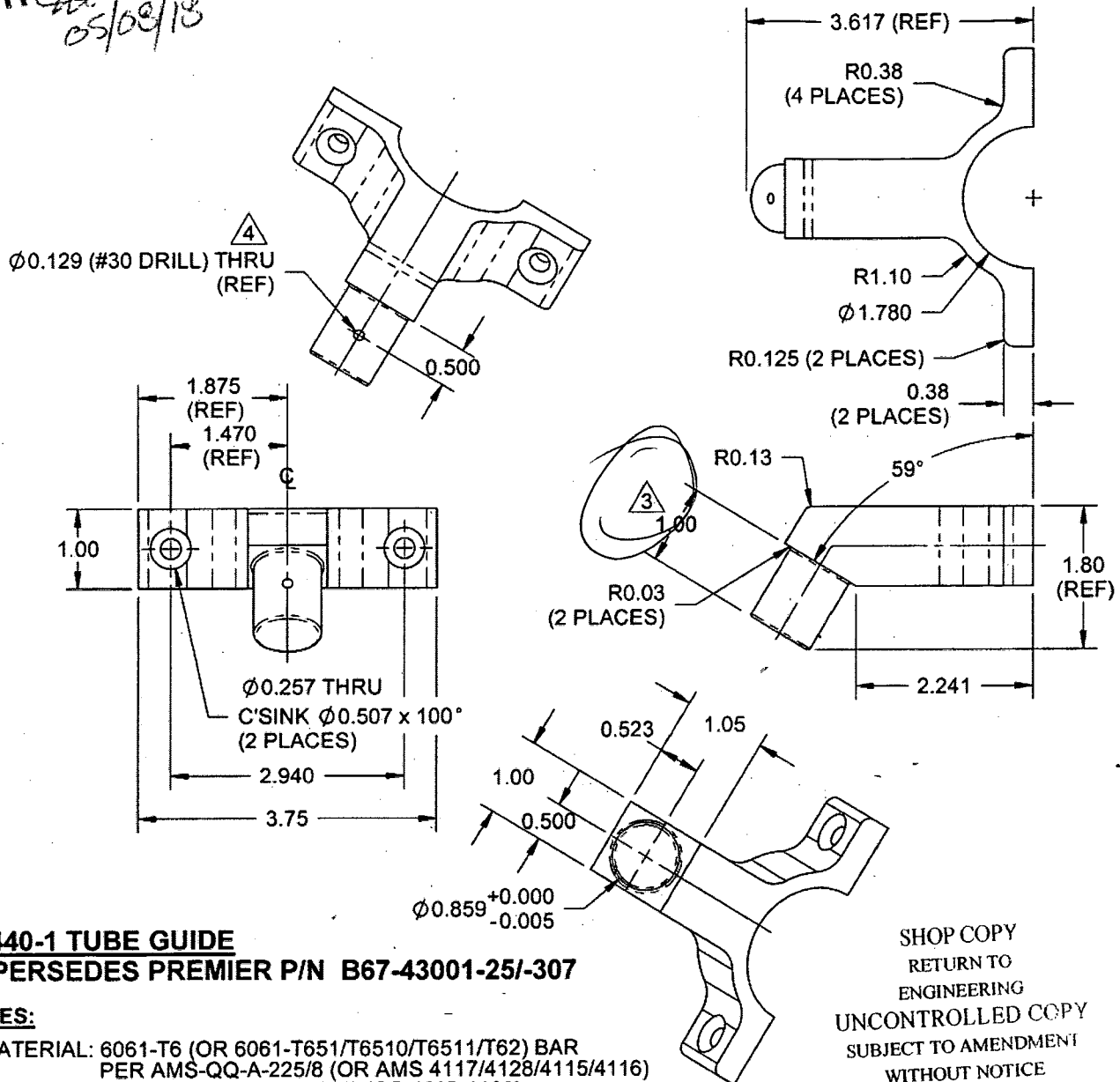
Part No: D3440-1 PAR #:          Fault Category: Prod-Eng-coordin NCR: Yes No DQA:    Date: 08/07/09  
D412-695 QA: N/C Closed:    Date: 08/07/09

NCR: 40047		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/09	7.0	During Powder coat inspection it was noticed that the parts are not the correct colour as per the Dwg. D3440-1. They were powder coated white when they should have been done in Green sandtex.	08/07/09	Change estimate to match the Dwg. correctly	08/07/09	08/07/09	08/07/09	08/07/09
		R.L. who says to powder coat in white. Does not correspond to the Dwg. W/O v.s. Dwg was not correctly verified.	08/07/09	<del>Sand blast with</del> <del>Remove white powder coat</del>	08/07/10	08/07/10	08/07/10	08/07/10
			08/07/10	Re do outline as per AS2005.	08/07/10	08/07/10	08/07/10	08/07/10
			08/07/10	Re Powder coat Green sandtex as per Dwg and as per AS2005 Start time 11:30 over temp 720	08/07/10	08/07/10	08/07/10	08/07/10
			08/07/10	Finish time 12:00	08/07/10	08/07/10	08/07/10	08/07/10
				Remind/Retrain employees to Read Dwg. Before Powder coating				

NOTE: Date & initial all entries

**DART****RELEASED**  
05/09/13

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3440</b>	REV. A SHEET 1 OF 7
DATE	05.06.02	TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:2
A	05.06.02	NEW ISSUE	



**D3440-1 TUBE GUIDE**  
**SUPERSEDES PREMIER P/N B67-43001-25/-307**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QT/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) MASK BEFORE PAINTING.
- 4) DRILL HOLE AT ASSEMBLY.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

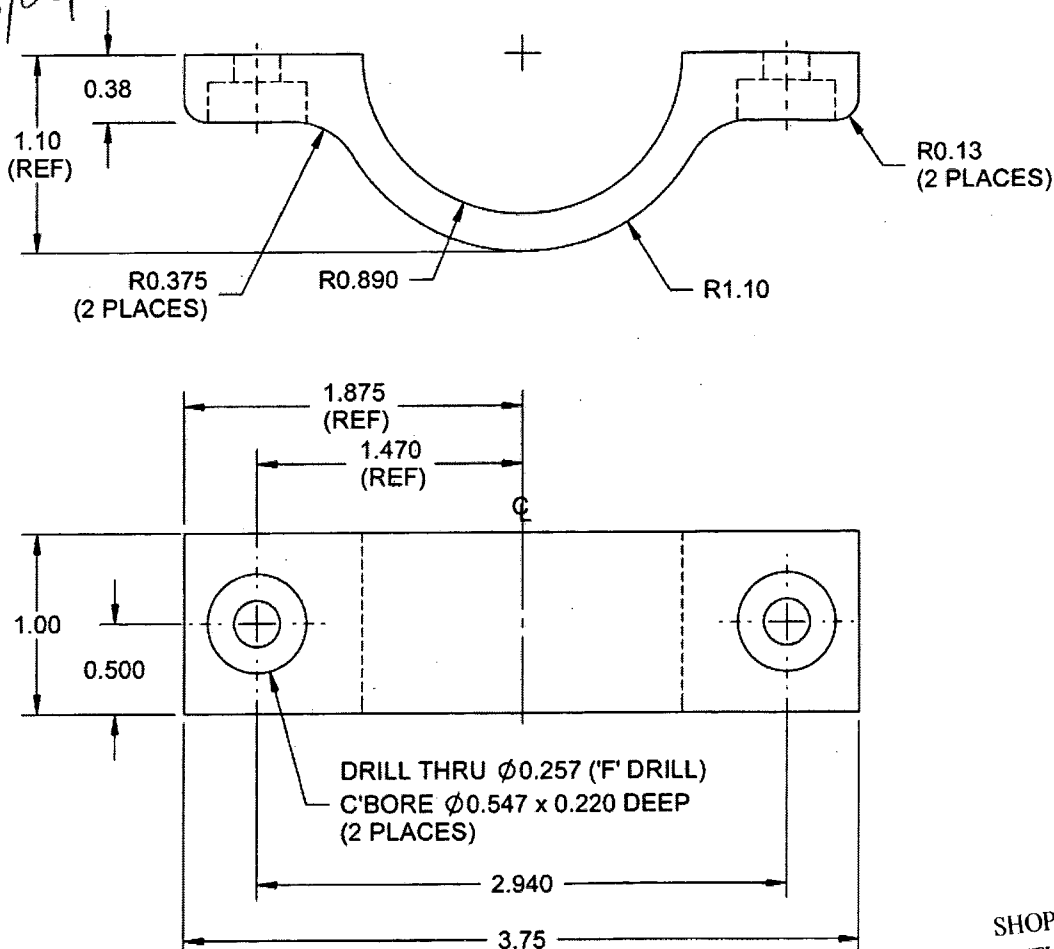
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3440</b>	REV. A SHEET 2 OF 7
DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1

**RELEASED**  
*[Signature]*  
05/08/18

**D3440-3 CLAMP**  
**SUPERSEDES PREMIER P/N B67-43001-309**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

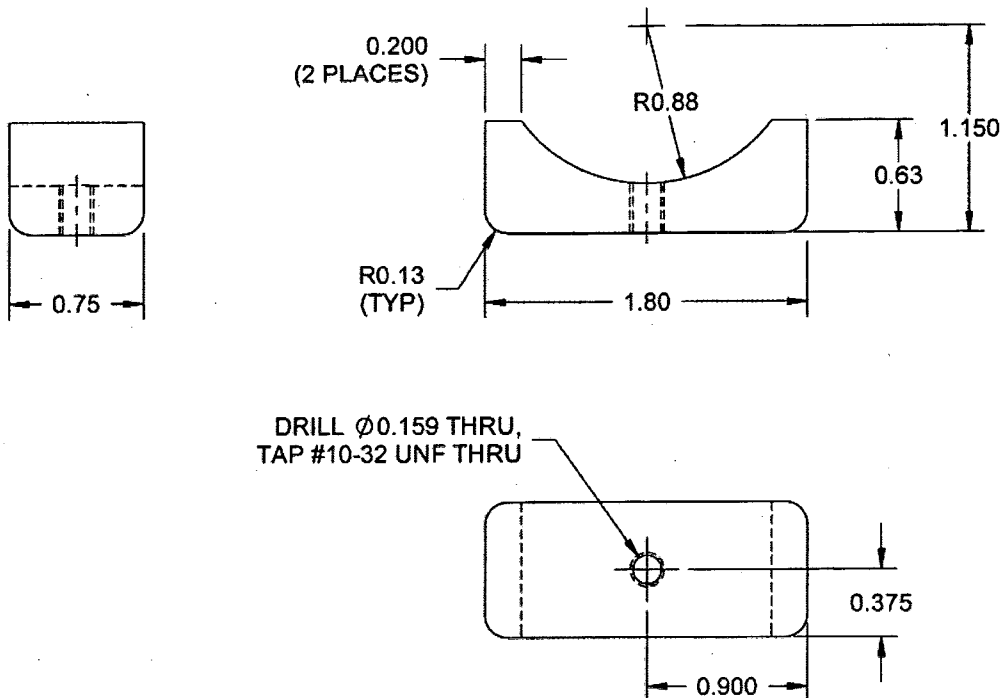
NOTE: Date & initial all entries



**DART**

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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1

**RELEASED**  
*[Signature]*  
05/08/18



**D3440-5 CONTOURED DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-217**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

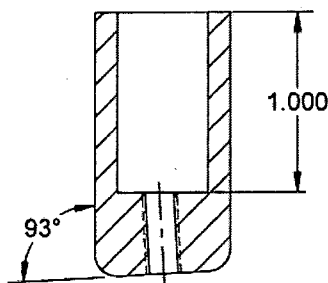
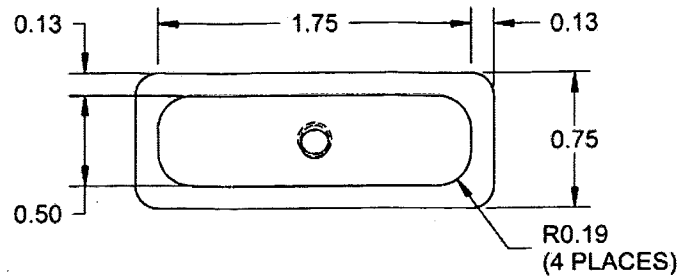
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

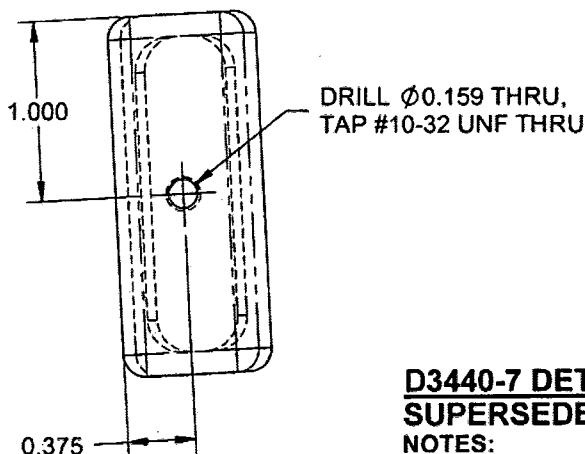
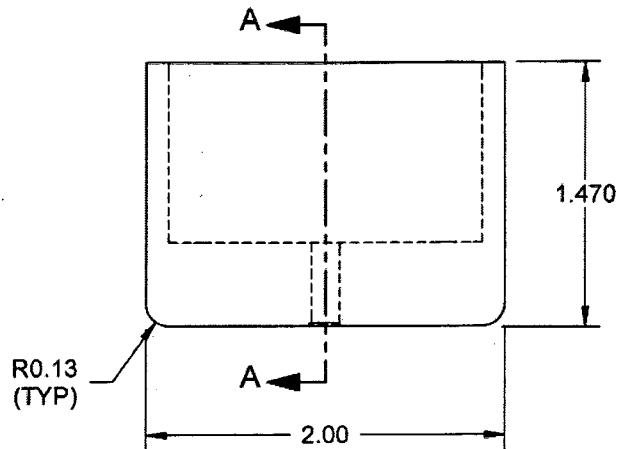
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3440</b>	REV. A SHEET 4 OF 7
DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1

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*[Signature]*  
05/03/18



SECTION A-A



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WORK ORDER  
NO. 40047

**D3440-7 DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-221**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

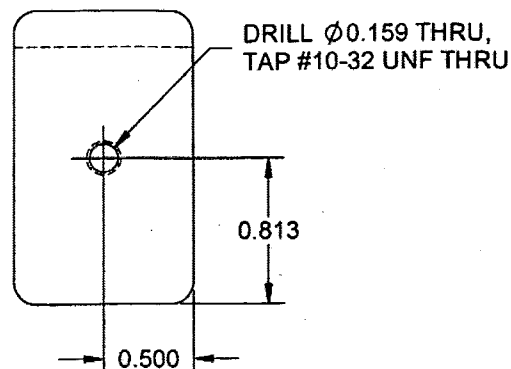
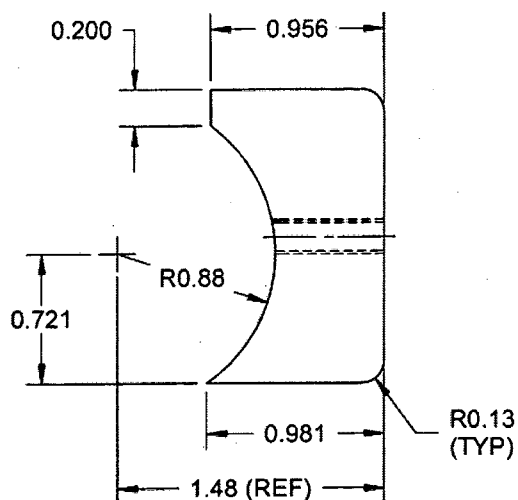
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

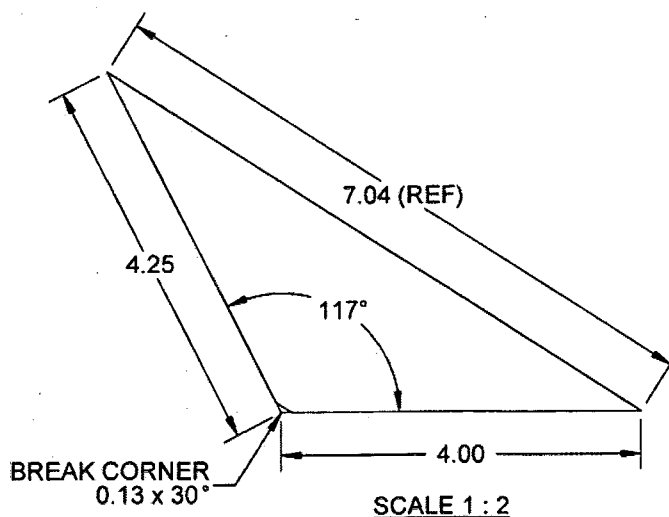
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3440</b>	REV. A SHEET 5 OF 7
DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1



**D3440-9 TUBE DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-241**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS-QQ-A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)

**RELEASED**  
*[Signature]*  
05/08/18



**D3440-11 GUSSET**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.250)

**NOTES:**

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

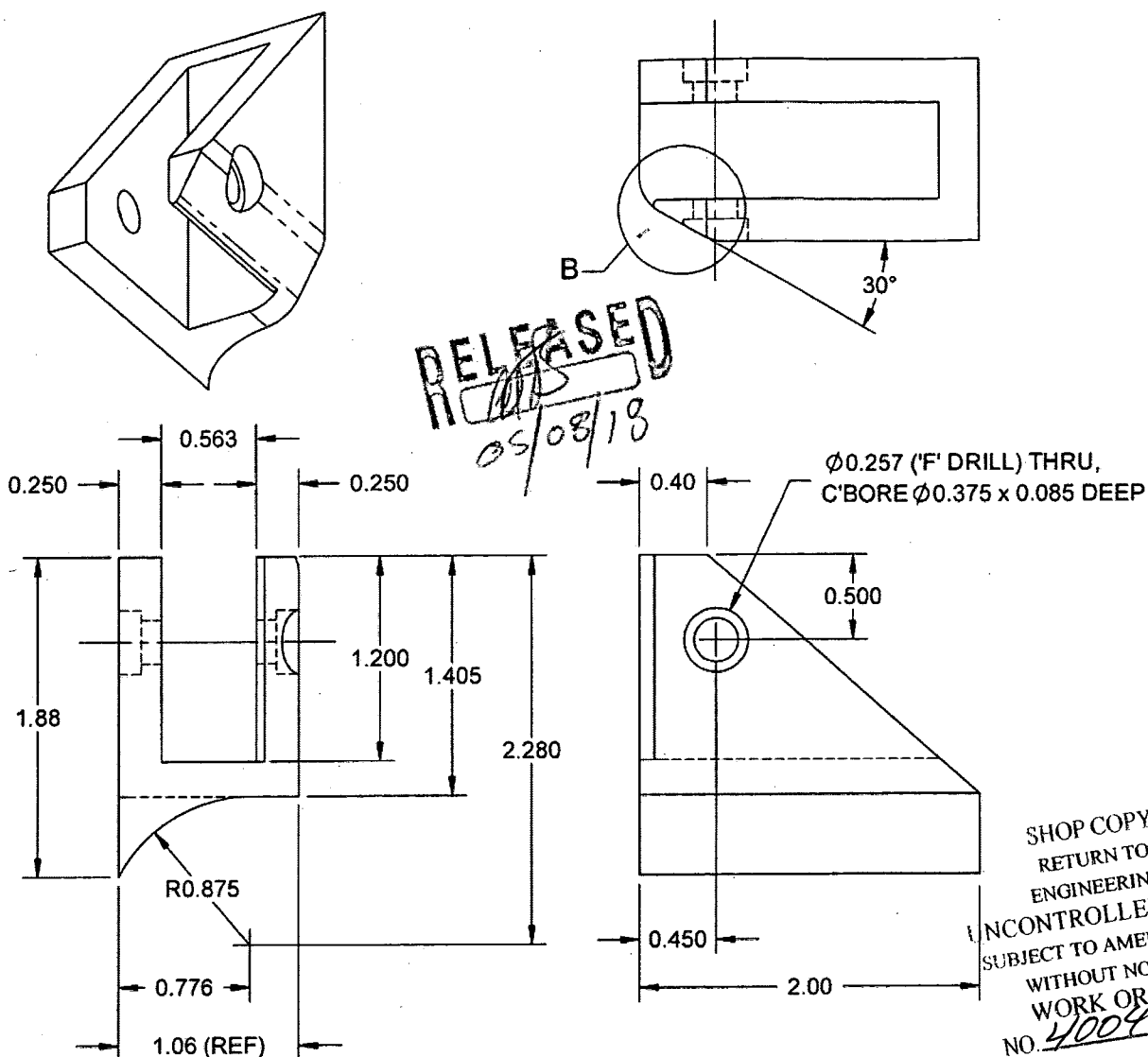
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



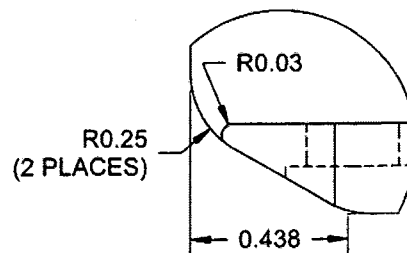
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3440</b>	REV. A SHEET 6 OF 7
DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1



**D3440-13 BRACKET**  
**SUPERSEDES PREMIER P/N B67-43001-273**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QT/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



**DETAIL B**  
**SCALE 2:1**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

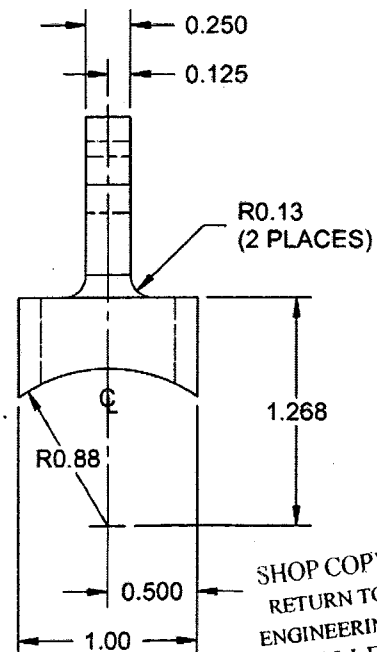
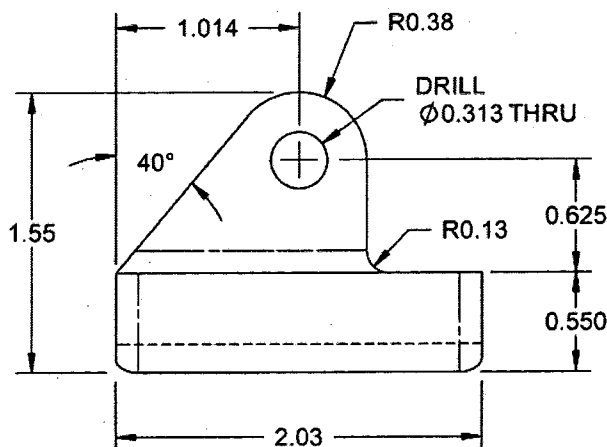
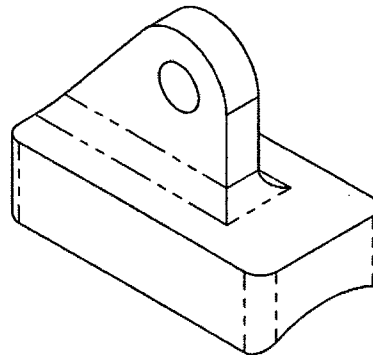
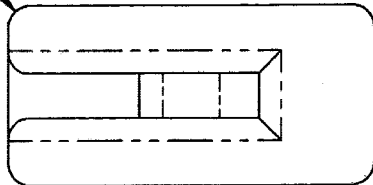


**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3440</b>	REV. A SHEET 7 OF 7
DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1

**RELEASED**  
*[Signature]*  
05/08/18

R0.13  
(4 PLACES)



**D3440-15 CONTOURED MALE EYE**  
**SUPERSEDES PREMIER P/N B67-43001-215**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 40042
Description: Tube Guide		Part Number: 3446-1
Inspection Dwg:	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.38	$\pm 0.030$	0.380	✓			
R1.10	$\pm 0.030$	1.100	✓			
$\phi 1.780$	$\pm$	1.780	✓			
R0.125	$\pm 0.010$	0.125	✓			
0.38	$\pm 0.030$	0.374	✓			
59°	$\pm 1/2^\circ$	59°	✓			
R0.13	$\pm 0.030$	0.130	✓			
1.00	$\pm 0.030$	1.000	✓			
R0.03	$\pm 0.030$	0.010	✓			
2.241	$\pm 0.010$	2.244	✓			
1.05	$\pm 0.030$	1.065	✓			
0.523	$\pm 0.010$	0.520	✓			
1.00	$\pm 0.030$	0.999	✓			
0.500	$\pm 0.010$	0.500	✓			
$\phi 0.859$	$\pm 0.000/-0.005$	0.858	✓			
1.00	$\pm 0.030$	0.999	✓			
$\phi 0.257$	$\pm 0.006/-0.001$	0.259	✓			
$\phi 0.507 \times 100^\circ$	$\pm 0.010 / \pm 1/2^\circ$	0.517	✓			
2.940	$\pm 0.010$	2.944	✓			
3.75	$\pm 0.030$	3.757	✓			

Measured by: <i>DH</i>	Audited by: <i>ML</i>	Prototype Approval: <i>N/A</i>
Date: 08/07/07	Date: 08/07/07	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	